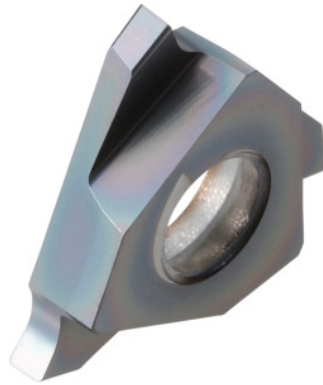


Garant
Grooving insert left-hand, HB9635, Slot width m (H13): 1,85mm

Order data

Order number	273908 1,85
GTIN	4045197768537
Item class	21J

Technical description

for circlips to DIN 471 / 472 ring thickness	1.75 mm
Blade width w	1.85 mm
Slot width m (H13)	1.85 mm
t_{\max}	2.5 mm
Finishing/roughing assignment	Skrubbearbejdning-sletbearbejdning
Tool material	Carbide
Corner radius R	0.2 mm
Insert assignment	left-hand
Grade	HB9635
Slots to standard	DIN 472
Slots to standard	DIN 471

Number of changes/inserts	3
Main application	P
Secondary application	M
Cutting conditions	continuous
Cutting speed v_c main application	110 - 170 mm/min
Cutting speed v_c secondary application	90 - 140 mm/min
Type of product	Indexable insert for grooving

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	150 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	90 m/min	P
INOX < 900 N/mm ²	suitable	140 m/min	M
INOX > 900 N/mm ²	suitable	140 m/min	M
GG(G)	suitable only under restricted conditions	170 m/min	K
continuous	suitable		
wet maximum	suitable		
dry	suitable		